

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 34616		
Estimate Number	: 10834		
P.O. Number	: N/A	Part Number	: D29332
This Issue	: 9/12/2007      S.O. No. : N/A	Drawing Number	: D2933.REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NA      Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 33668	Material	: NA
Written By	: _____	Due Date	: 10/5/2007      Qty:      6   Um:      Each
Checked & Approved By	: _____		
Comment	: Est: B 00.06.26    New DWG rev (mpp 2069)   EC Est Rev:C   As per Rev C 07-03-19   JLM		

[illegible][illegible][illegible]

P10

[illegible]



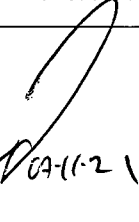
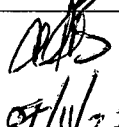
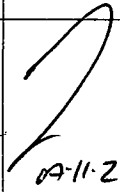
**Abstract**

[illegible][illegible]

07/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2933-2 PAR #: N/A Fault Category: Prod / Machine <sup>Part 5</sup> NCR: Yes No DQA: D Date: 07/11/23  
 QA: N/C Closed: KJ Date: 07.11.23

NCR: 34616		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-21	2.0	Upon profile line, chips of material were pressed in under the saddle (key way location), lifting the part, causing it to become too thin on 2 sides. 0.020" under tolerance. <del>tolerance.</del>	 07/11/22	- Scrap & replace, due to further work will result in unacceptable measurements, i.e.: keep way & material thickness. - Tool was lifted to cut from a different spot.	 07-11-21	 07-11-21	 07/11/22	 07-11-21

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 34616

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/11/21

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 07-11-22

(6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

BR 07-11-22

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS 07/11/22

(X6)

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 428A

(6)

AS 07/11/22

(X6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/11/23

Job Completion



U 07-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34616
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.120	0.120	0.120	0.120		
B	0.100	0.140		0.119	0.119	0.120	0.120		
C	0.100	0.140		0.123	0.125	0.128	0.127		
D	0.210	0.230		0.220	0.220	0.220	0.220		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.238	0.238	0.238		
N	0.100	0.140		0.123	0.124	0.124	0.124		
O	0.540	0.560		0.540	0.554	0.553	0.553		
P	0.490	0.510		0.503	0.502	0.503	0.503		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.491	2.491	2.491	2.491		
S	0.240	0.270		0.251	0.250	0.251	0.251		
T	0.100	0.180		0.138	0.140	0.141	0.140		
U	1.625	1.635		1.629	1.628	1.629	1.629		
V	1.362	1.372		1.365	1.365	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.136	1.136	1.135		
Y	1.565	1.585	DT8695 A/B	1.573	1.573	1.573	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ML</i>
Date:	07/11/21

Audited by:	<i>SL</i>
Date:	07/11/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34616
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C		Page 1 of 1

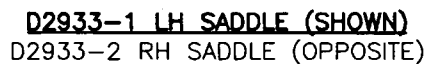
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AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>One</i>
Date:	07/11/21

Audited by:	3L
Date:	07/11/21

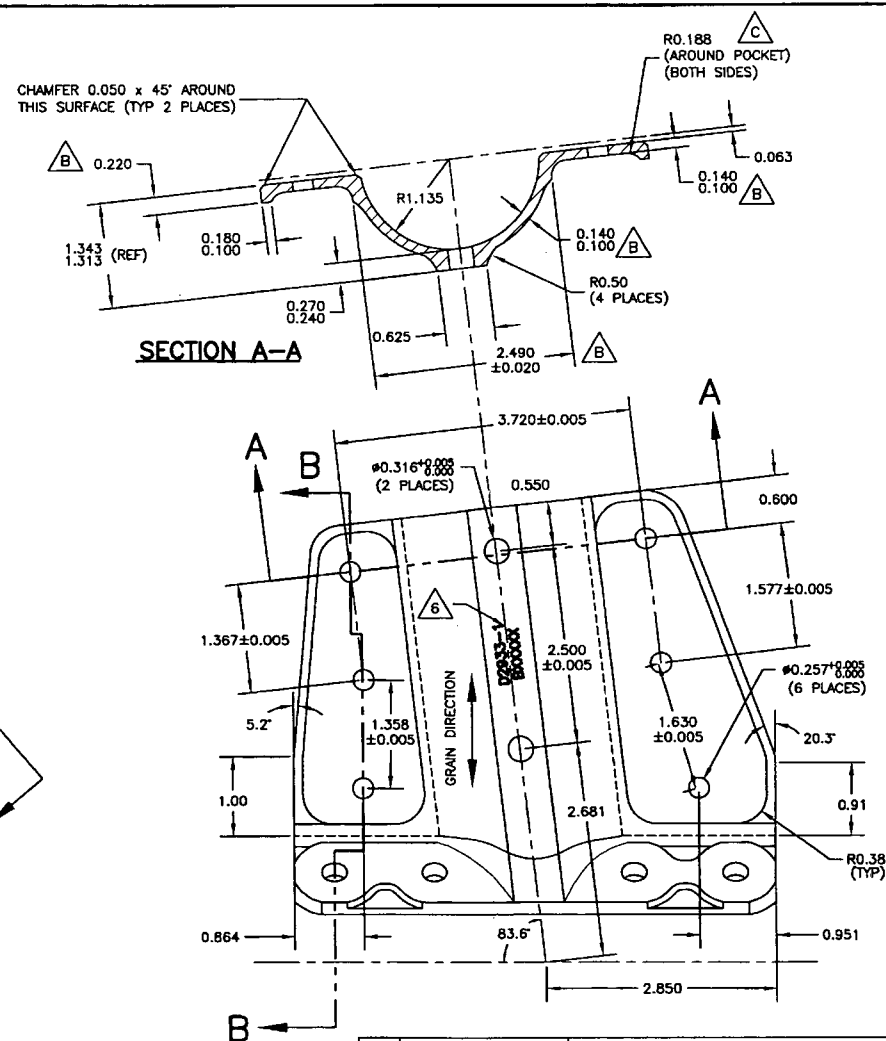
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>




- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

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WITHOUT NOTICE  
WORK ORDER  
NO. 34616

07.02.12



C	06.11.09	R0.188 WAS R0.20 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> BELLEVILLE, ILL.
CHECKED	APPROVED	
DATE	TITLE	
06.11.09	SADDLE INSIDE	REV. 4 SHEET 1 OF 2 SCALE: 2:1

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